

Date: Wednesday, 3/8/2006 10:42:30 AM
 User: Kim Johnston

Process Sheet

16

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206B UTILITY BASKET
 Job Number : 26139
 Estimate Number : 11282
 P.O. Number : N/A Part Number : D206540013
 This Issue : 3/8/2006 S.O. No. : N/A Drawing Number : ~~UNDER REVIEW~~ D206-540 06.03.08
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : 1
 Previous Run : 22087 Material : N/A
 Written By : SEE COMMENT REV Due Date : 4/20/2006 Qty: 1 Um: Each
 Checked & Approved By : 06.03.08
 Comment : Est Rev:1 Revised as per Rev I 05-12-07 JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD206-540-013 CHG004

DA 06/04/06

2.0	26139A	206B BASKET LID
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Comment: Sub-Component 206B BASKET LID

3.0	26139B	206B BASKET BASE
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Comment: Sub-Component 206B BASKET BASE

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

5.0	D2332041	Lid Prop Assembly 6.69"
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y B25136

6.0	D2022101	Spacer
-----	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2022-101 SPACER B23396

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206B UTILITY BASKET

Job Number: 26139

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment B24876

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring B24532

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing B25826

10.0

D2931

Bumper



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 D2931 Bumper B21139

11.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS20600AD4W3 Rivet M13767

12.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN4-7A Bolt M18369

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 206B UTILITY BASKET

Job Number: 26139

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-24A

Bolt M17204

14.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt M19413

15.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-22A

Bolt M18822

16.0

AN517A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s) *?

Pick: Assembly Kit

Qty Part Number

Description Batch

4 ~~AN5-17A~~

Bolt M19551

M1904104

17.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD416

Washer M19025

18.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD516

Washer M18254

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: 206B UTILITY BASKET

Job Number: 26139

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer M18 918 ✓

20.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD8 Washer M11729 ✓

21.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M18917 ✓

22.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) M19099 ✓

23.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5) M19073 ✓

JAD 06:04:01 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 26139

Part Number: D206540013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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24.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D206-540

SAD 06:04:04

①

25.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

26.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Pick: Packing Kit

27.0	D2249041	Fitting Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit
2 D2249-041 Braket

23776 v1 -
22498 x1 -

28.0	D2022101	Spacer
------	----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit
4 D2022-101 Spacer

23396 ✓

29.0	D2012107	Clevis
------	----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit
1 D2012-107 Clevis

25483 ✓

30.0	D2258170	Placard - 170 lb
------	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2258-170 Placard

B16266 ✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-04-04	24	Moved Add D2258-170 : 2 B2255 placemnts to Ass'y to Ass'y B16266 B40671 2x D2728-3(B22553) Change Made.	EC	06.04.07			2 06.04.04

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 2 Date: 06/04/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 26139

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

D2259

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2259 Placard

10671 ✓

32.0

D2525

Spacer Kit



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2525 Spacer kit

12105 ✓

33.0

D2526

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2526 Bushing

17519 ✓

34.0

D2748

Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2748 Clevis

15196 ✓

35.0

D27491

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2749-1 Strut

23423 ✓

36.0

D27493

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2749-3 Strut

23424 ✓

37.0

D2814

Strut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2814 Strut

25296 ✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 206B UTILITY BASKET

Job Number: 26139

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN4-12A

Bolt

18822 ✓

39.0

AN412

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-12 ✓ Bolt

7188 ✓

40.0

AN45A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

8 AN4-5A Bolt

100089 ✓

41.0

AN517A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN5-17A Bolt

19551 ✓

42.0

AN421A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-21A Bolt

2951 ✓

43.0

AN960JD416

Washer



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

19 AN960JD416

Washer

19085 ✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 26139

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

44.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN960JD516 Washer

18254 ✓

45.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 AN970-4 Washer

18918 ✓

46.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4)

19099 ✓

47.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 MS21042L5 Nut

19073 ✓

48.0

MS27039411

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 MS27039-4-11 Screw

3355 ✓

49.0

AN46

Bolts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 AN4-6 Bolt

9599 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:42:31 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 26139

Part Number: D206540013

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

50.0	AN3204	Nut
------	--------	-----



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

3 AN320-4 Nut

7188 ✓

51.0	AN38022	Cotter Pins
------	---------	-------------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

3 AN380-2-2 Cotter pin

16895 ✓

AP 06/04/05

52.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

AP 4/4/5 (1)

53.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-540-013

Location: _____

PPP Rev: H

AP 4/4/5 (1)

54.0	DC	DOCUMENT CONTROL
------	----	------------------



Comment: DOCUMENT CONTROL

Inspection Level 21

AP 06/04/05 (1)

Job Completion



W 06/04/05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-540	REV. 1 SHEET 1 OF 8
DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION	SCALE NTS
C	94.07.28	REVISED DRAWING	
D	94.11.12	ADDED D2323 STRUT	
E	94.11.12	CHANGED SECTION C-C	
F	94.11.12	ADDED HANDLE AND LID PROP	
G	99.09.21	REDRAW, CHANGE LATCH/HINGE/STRUTS	
H	99.12.02	INCORPORATE DSI 9174 / DEO 9167	
I	05.11.10	REPLACED PIANO HINGE SYSTEM	

Qty -011	Qty -013	Part No.	Description
X		D206-540-011	BASKET INSTLN - BELL 206L/L1/L3/L4
	X	D206-540-013	BASKET INSTLN - BELL 206A/B
	1	D2012-107	CLEVIS
2	6	D2022-101	SPACER
2	2	D2249-041	BRACKET
1		D2252-041	BASKET ASSEMBLY
1		D2252-043	LID ASSEMBLY
1	1	D2258-170	PLACARD
1	1	D2259	PLACARD*
	1	D2330-041	BASKET ASSEMBLY
	1	D2330-043	LID ASSEMBLY
1	1	D2332-041	LID PROP ASSEMBLY
2	2	D2525	SPACER KIT
2	2	D2526	BUSHING
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
2	2	D2537	BUSHING
2	2	D2748	CLEVIS
	1	D2749-1	STRUT
	1	D2749-3	STRUT
1		D2749-5	STRUT
1		D2749-7	STRUT
	2	D2814	STRUT
4	4	D2931	BUMPER
2	2	AN3-16A	BOLT
	3	AN320-4	NUT
	3	AN380-2-2	COTTER PIN
	2	AN4-12	BOLT
2	2	AN4-12A	BOLT
2	2	AN4-21A	BOLT
1	1	AN4-22A	BOLT
1	1	AN4-24A	BOLT
8	8	AN4-5A	BOLT
	1	AN4-6	BOLT
2	2	AN4-7A	BOLT
6	6	AN5-17A	BOLT
16	23	AN960JD416	WASHER
6	6	AN960JD516	WASHER
4	4	AN960JD8	WASHER
4	5	AN970-4	WASHER
4	4	MS20600AD4W3	RIVET
2	2	MS21042L3	NUT (OR MS21042-3)
8	8	MS21042L4	NUT (OR MS21042-4)
6	6	MS21042L5	NUT (OR MS21042-5)
	1	MS27039-4-11	SCREW

*NOTE: Placard D2259 to be installed in cock pit near the airspeed indicator.

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SUBJECT TO AMENDMENT
WITHOUT NOTICEWORK ORDER
NO. 26139

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DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-540	REV. 1 SHEET 2 OF 8
DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION	SCALE NTS

WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-540-011	70 lb	40.0 in	2800 in-lb	111.0 in	7770 in-lb
206 L Series Basket Installation	31.8 kg	1.0 m	31.8 m-kg	2.8 m	89.0 m-kg
D206-540-013	50 lb	40.0 in	2000 in-lb	99.0 in	4950 in-lb
206 A/B Series Basket Installation	22.7 kg	1.0 m	22.7 m-kg	2.5 m	56.8 m-kg

GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification. This basket can only be installed on the starboard side of the aircraft on high gear. Ensure that any steps that are outboard of the crosstubes are removed.

WORKMANSHIP

Unless otherwise stated, all workmanship should be to the standard set by the Aircraft Maintenance Manual.

CONTINUING AIRWORTHINESS

This installation should be maintained in accordance with the Maintenance Manual Supplement **MMS-D206-540**.

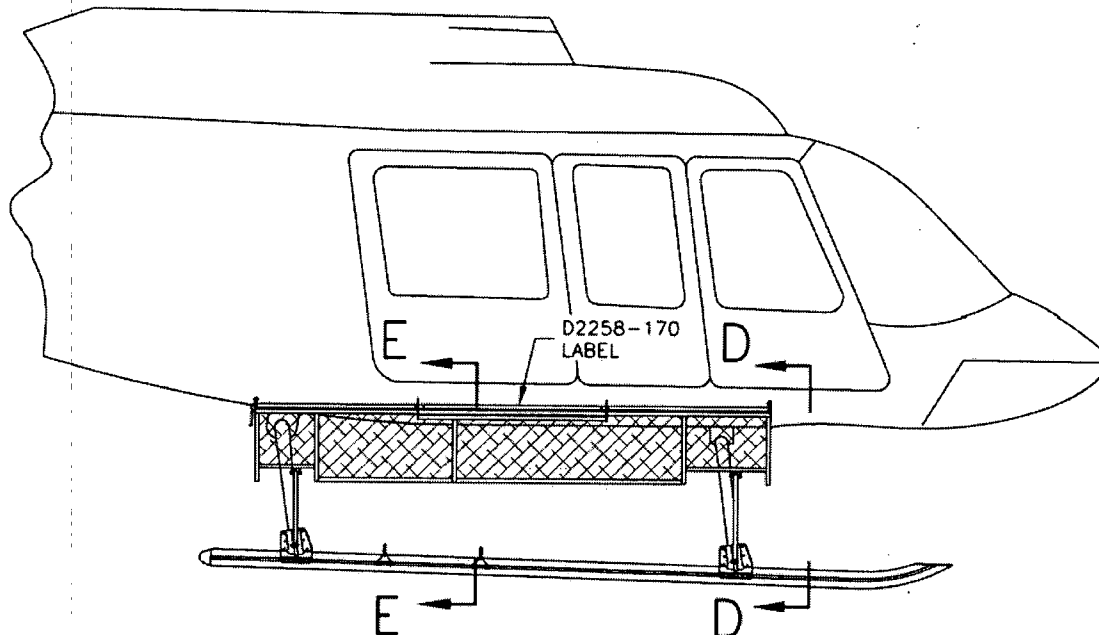
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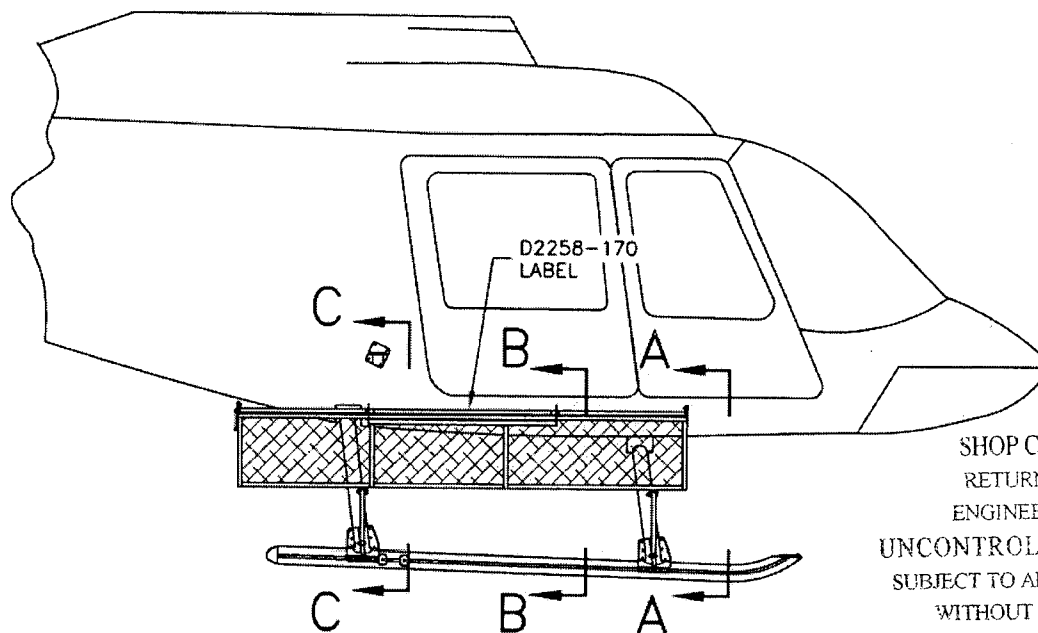
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DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D206-540	REV. 1 SHEET 3 OF 8
DATE 05.11.10	TITLE UTILITY BASKET INSTALLATION		SCALE NTS



D206-540-011 206L/L1/L3/L4 BASKET INSTALLATION



D206-540-013 206A/B BASKET INSTALLATION

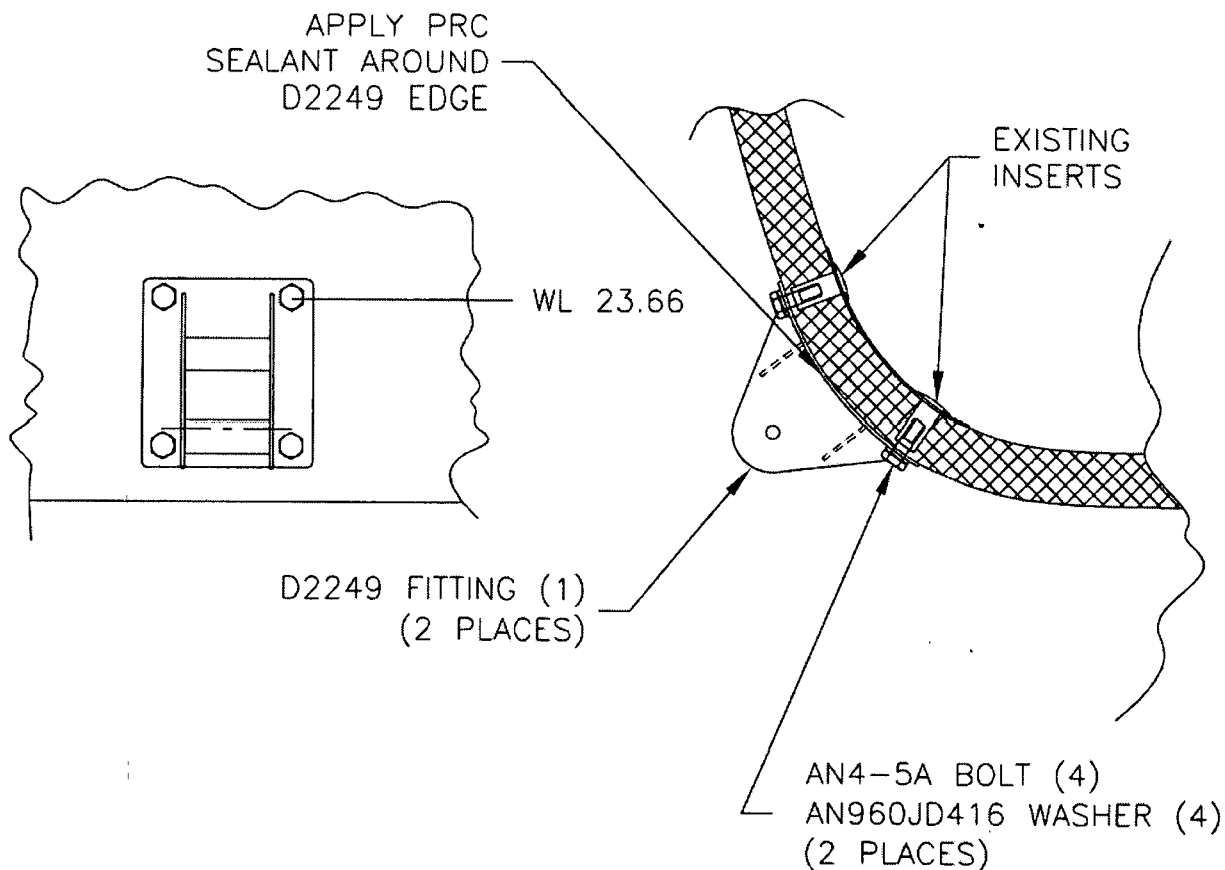
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NO. 26139

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DATE 05.11.10	TITLE UTILITY BASKET INSTALLATION		SCALE NTS



BRACKET DETAIL

REPLACE 206-031-370-6
AND 206-031-370-8 STEPS AS
REQUIRED WITH D2249 FITTINGS.
REFER TO SERVICE INSTRUCTION
BHT-206-SI-22

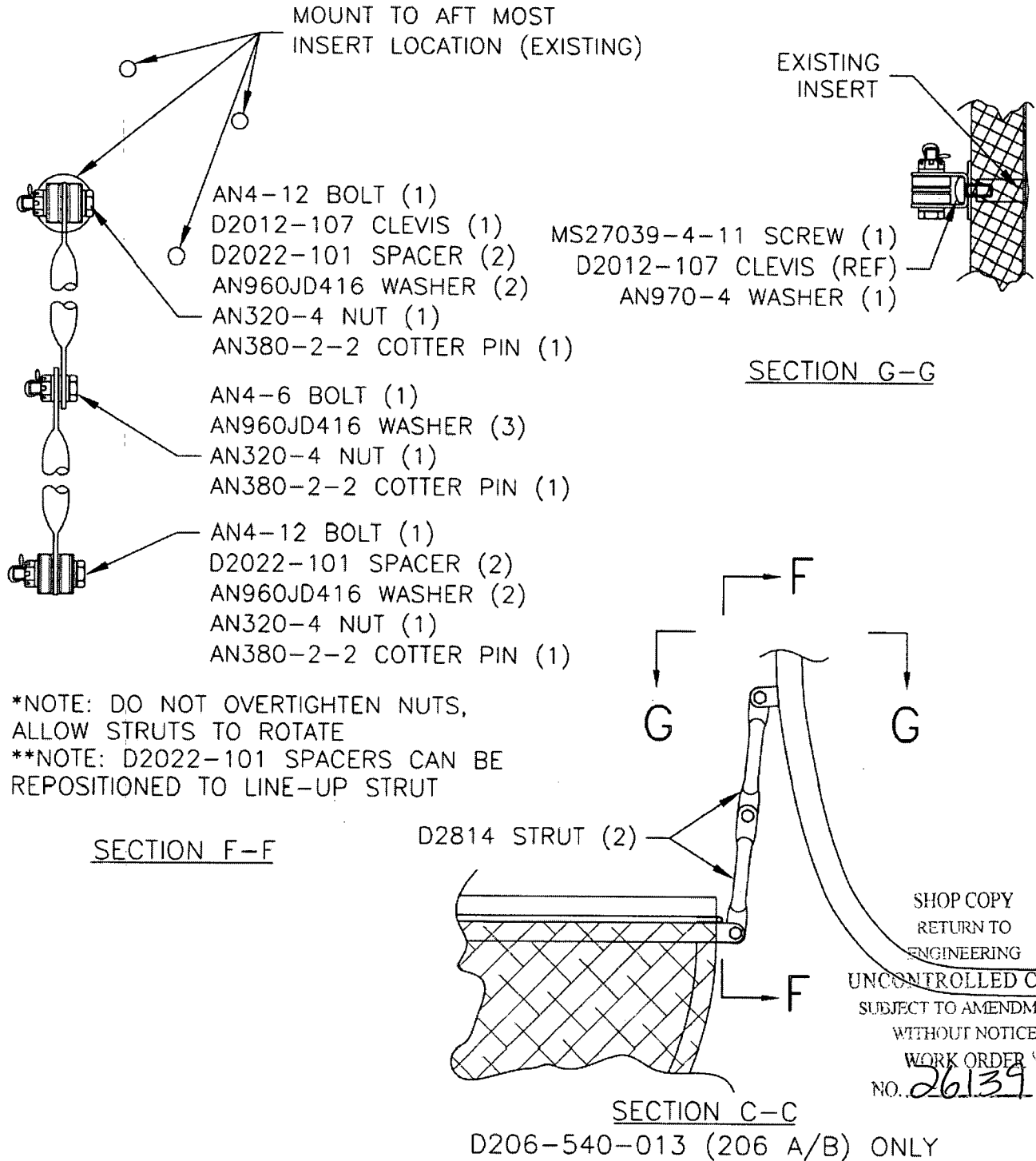
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DATE 05.11.10	TITLE UTILITY BASKET INSTALLATION		SCALE NTS

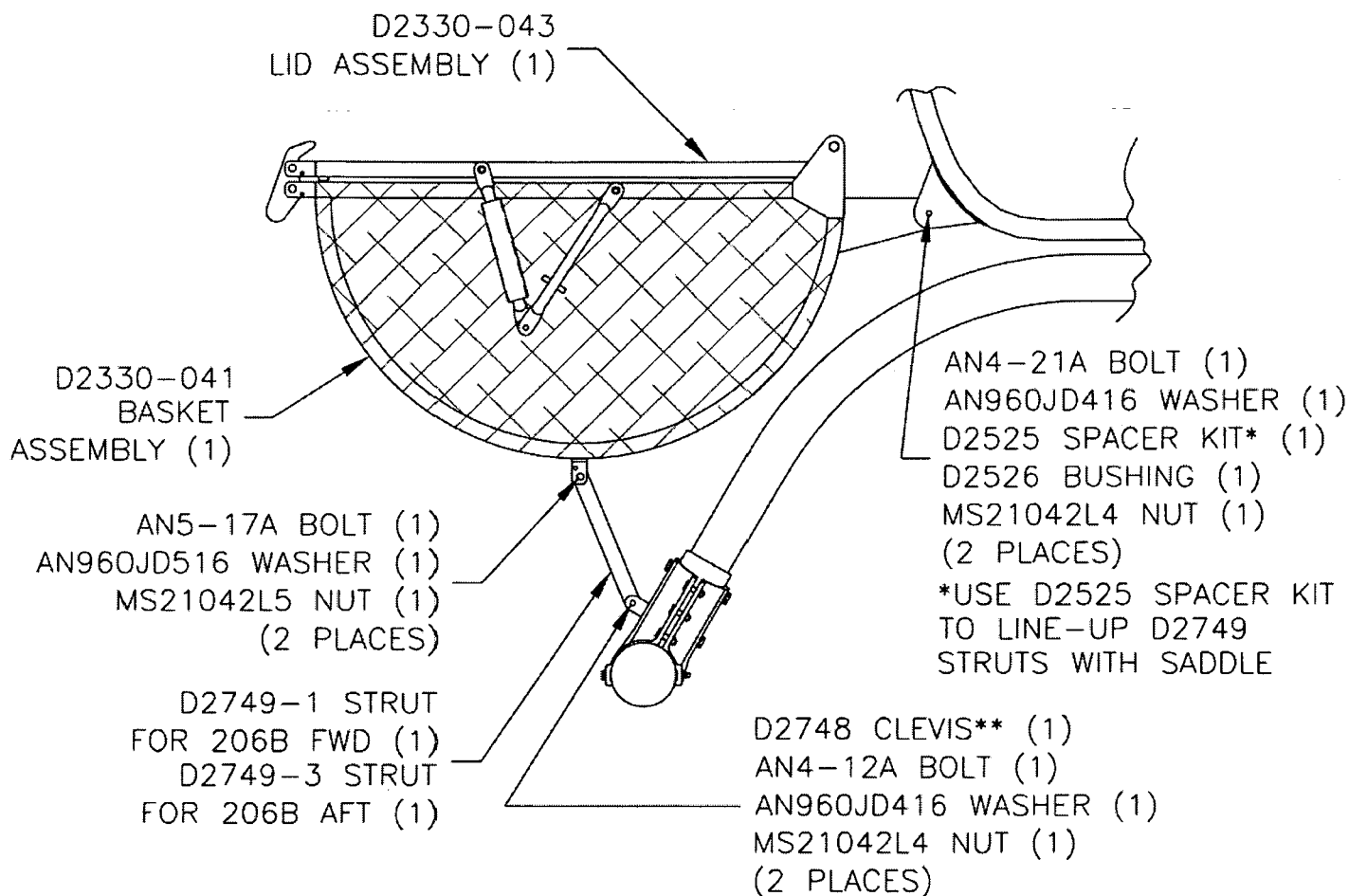


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<i>[Signature]</i>	<i>[Signature]</i>	D206-540	SHEET 6 OF 8
DATE	TITLE	SCALE	
05.11.10	UTILITY BASKET INSTALLATION	NTS	



**NOTE: REPLACE EXISTING SADDLE WASHER WITH D2748
CLEVIS AND RE-ATTACH USING EXISTING SADDLE HARDWARE

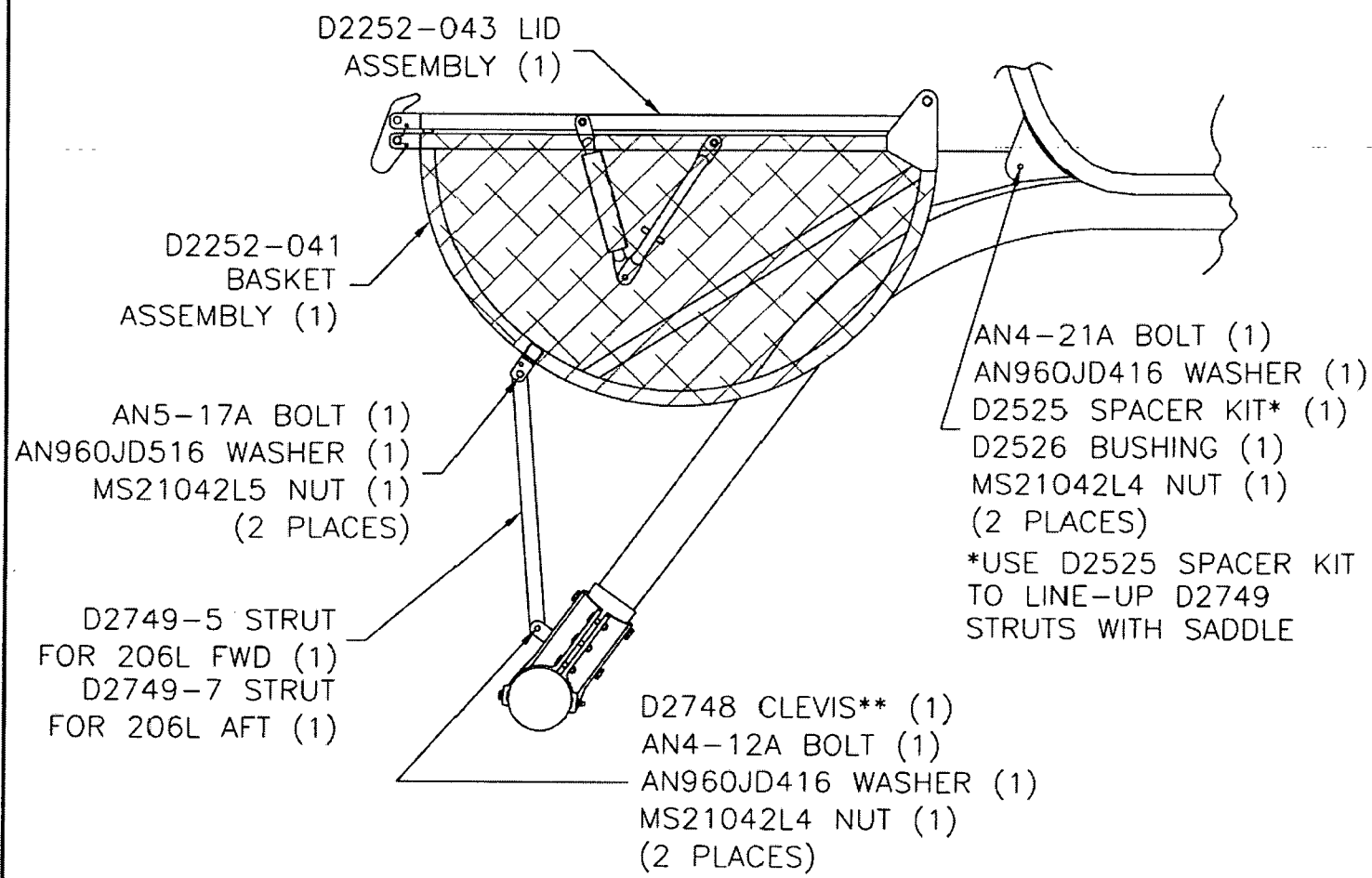
SECTION A-A AND B-B

D206-540-013 (206 A/B) ONLY

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DATE	05.11.10			D206-540	SHEET 7 OF 8
				TITLE	SCALE
				UTILITY BASKET INSTALLATION	NTS



**NOTE: REPLACE EXISTING SADDLE WASHER WITH D2748 CLEVIS AND RE-ATTACH USING EXISTING SADDLE HARDWARE

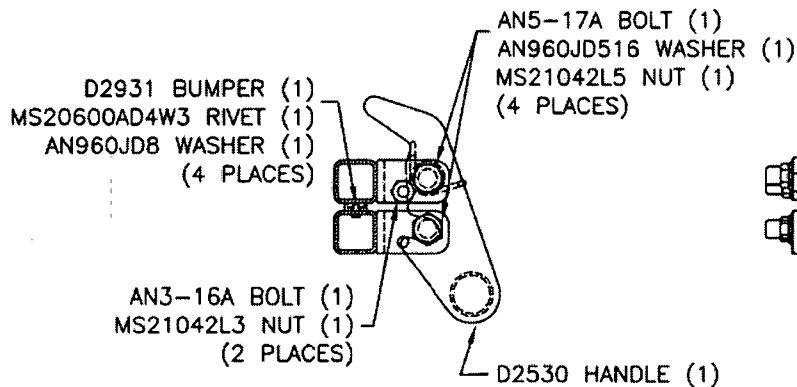
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SECTION D-D AND E-E
D206-540-011 (206 L/L1/L3/L4) ONLY

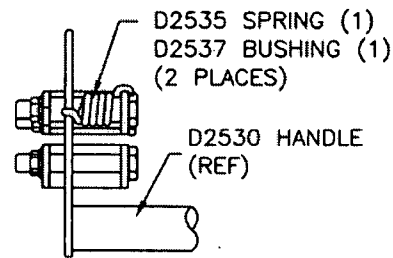
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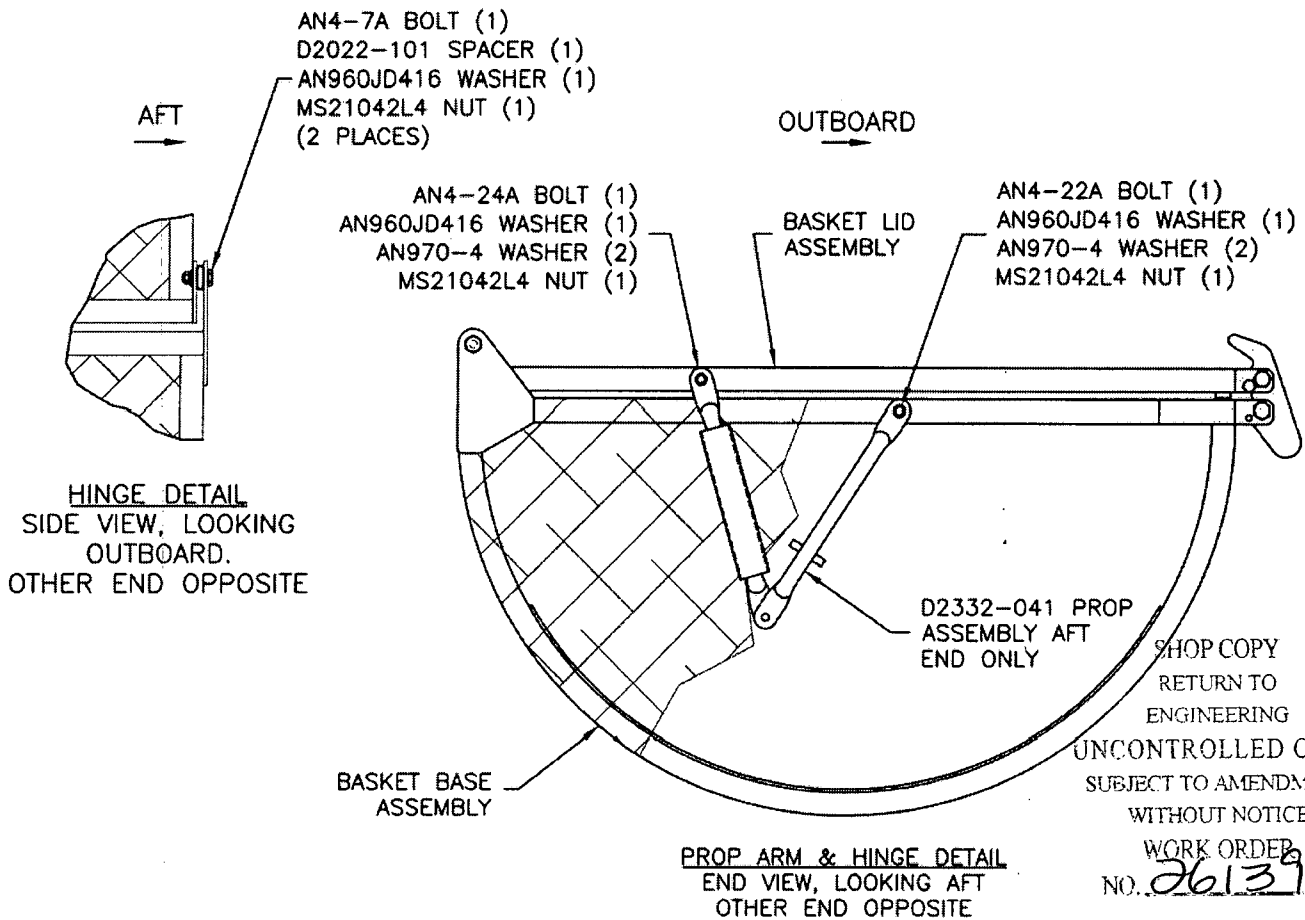
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CHECKED H	APPROVED H	DRAWING NO. D206-540	REV. 1 SHEET 8 OF 8
DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION	SCALE NTS



LATCH DETAIL



SPRING DETAIL



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Date: Wednesday, 3/8/2006 10:42:42 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206B BASKET LID
Job Number : 26139A	
Estimate Number : 11280	
P.O. Number : N/A	Part Number : D2330043
This Issue : 3/8/2006 S.O. No. : N/A	Drawing Number : UNDER REVIEW D2330
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : E
Previous Run : 22087A	Material : N/A
Written By : <u>See Comment Below</u>	Due Date : 4/15/2006 Qty: 1 Um: Each
Checked & Approved By : <u>06.03.08</u>	
Comment : Est Rev: H 0209.04 M304EX0.75-16F was M750-16FXS-S/S K	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 23.3625 f(s)/Unit Total : 23.3625 f(s) M100138 → 128.26
 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: M100282 → 218.26

06/03/22

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1- Cut D2330-1-3-9 as per Dwg D2330

2-Drill hole in D2330-3 as per Dwg D2330

3-Deburr

06/03/22 ①

3.0	D22321	Hinge
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2232-1	HINGE	B23445

06/03/22 ①

4.0	D2329	Label Plate
-----	-------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2329	Label Plate	B23490

06/03/22 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:42:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID

Job Number: 26139A

Part Number: D2330043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23271

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-1 Bushing B24873

AD 06/03/22 ①

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Chancel B25834

AD 06/03/22 ①

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)

Pick:

Qty Part Number Description Batch

18 sf M304EX0.75-16F Expanded Metal M100230

AD 06/03/22 ①

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner Jig

Deburr as required

A/R SS ROD Batch: M19555

AD 06/03/27 ①

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-03-28 ①

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a-m 06-03-29 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:42:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID

Job Number: 26139A

Part Number: D2330043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M *0h 03 30* *(1)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



66 *06-05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

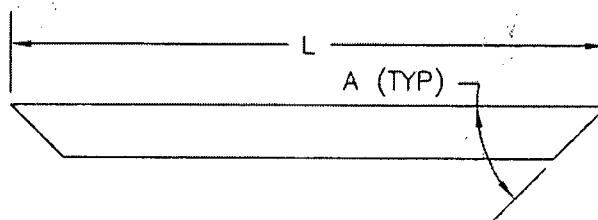
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DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS
C	96.05.23	ADDED LATCH AND LABEL PLATE	
D	99.09.14	MODIFIED LATCH, REDREW	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS' TO LID FRAME, ADDED D2232-1/-3 & D2330-11	

Qty -041	Qty -043	Part Number	Description	L	A
X		D2330-041	BASKET ASSEMBLY		
	X	D2330-043	LID ASSEMBLY		
1		D2012-107	CLEVIS		
4		D2235-1	RIB		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
2		D2330-1	FRAME	84.00 ✓	45
2	2	D2330-3	FRAME	25.50 ✓	45
1		D2330-5	FRAME	32.75 ✓	90
1		D2330-7	FRAME	24.25 ✓	90
1	2	D2330-9	FRAME	24.00 ✓	90
	2	D2330-11	FRAME	83.27 ✓	45
	2	D2330-13	FRAME	23.63 ✓	90
	1	D2330-15	FRAME	33.00 ✓	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE
(REF. DART SPEC. M304TS0.075W.0.60)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

CUT SIZE DETAIL

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NO. **26139A**

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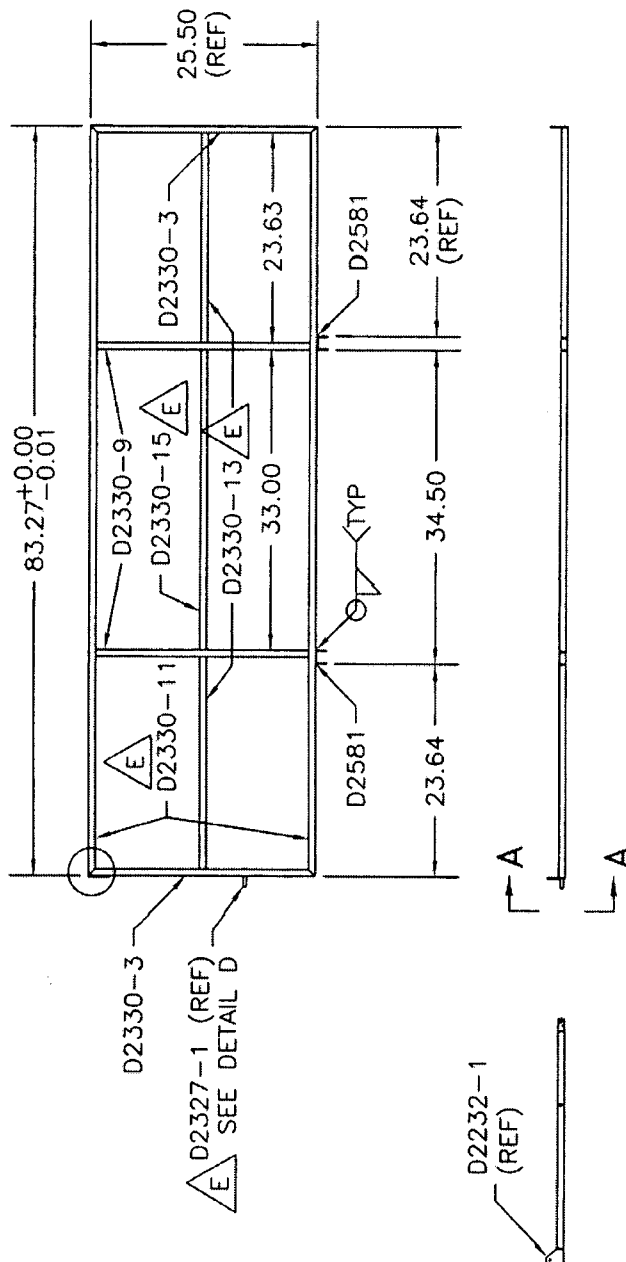
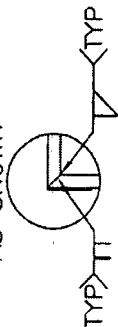
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206B)		SCALE NTS

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WELD ALL JOINTS
AS SHOWN

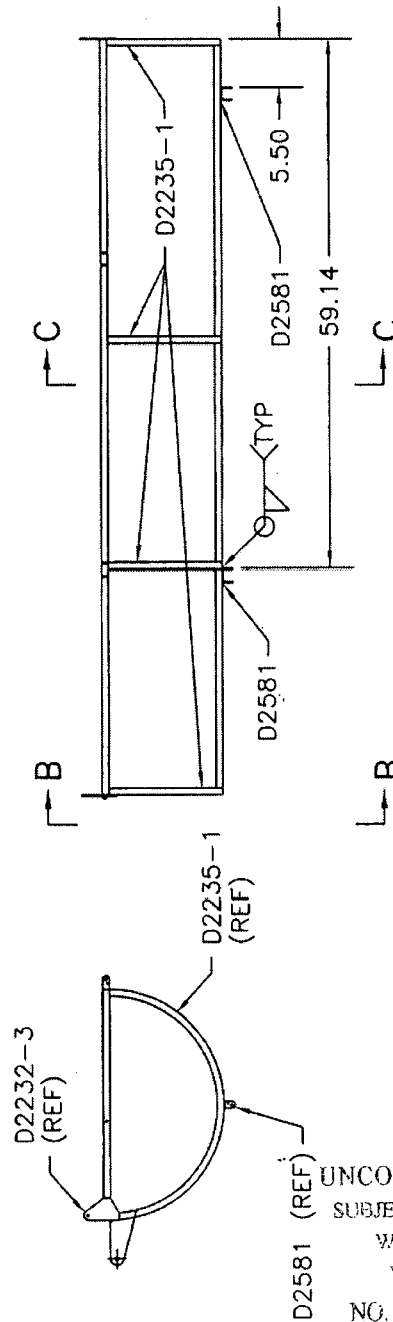
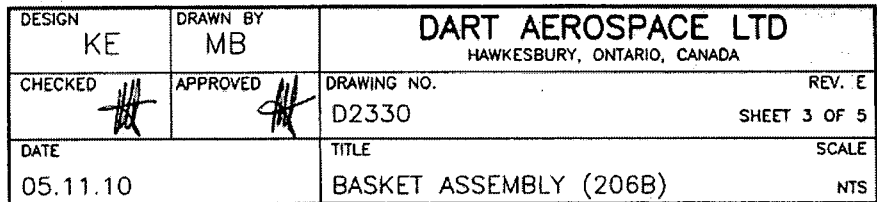


D2330-043 LID FRAME

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D2330--041 BASKET FRAME

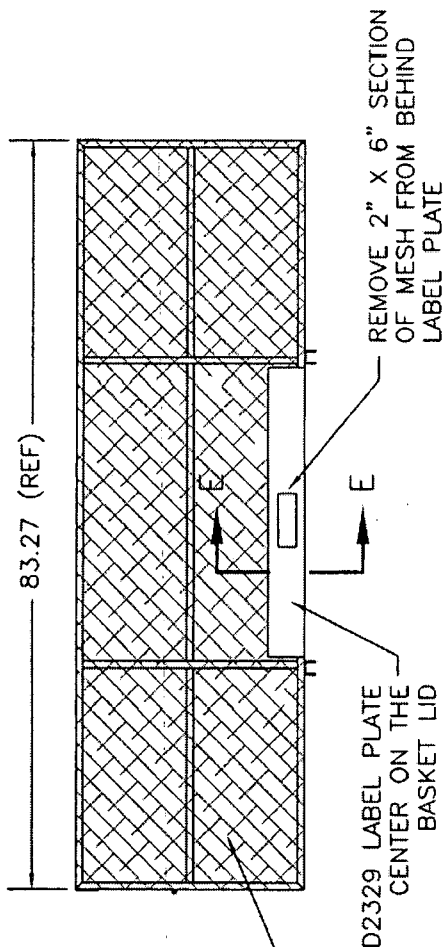
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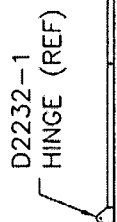
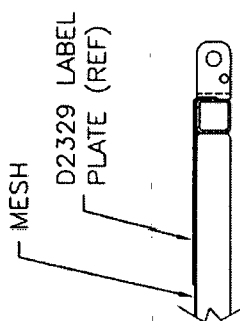
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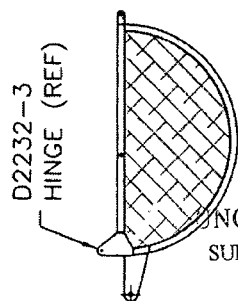
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DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS



D2330-041 BASKET ASSEMBLY



SKIN WITH 3/4-16 F EXPANDED SS, TACK WELD EACH STRAND END TO FRAME



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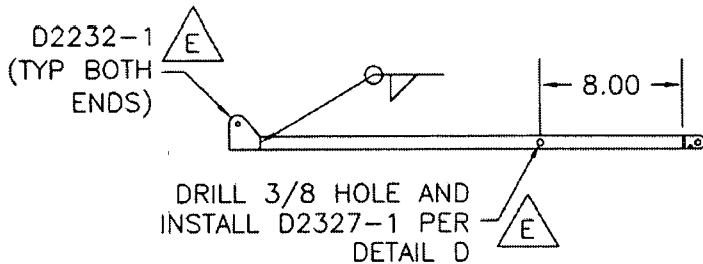
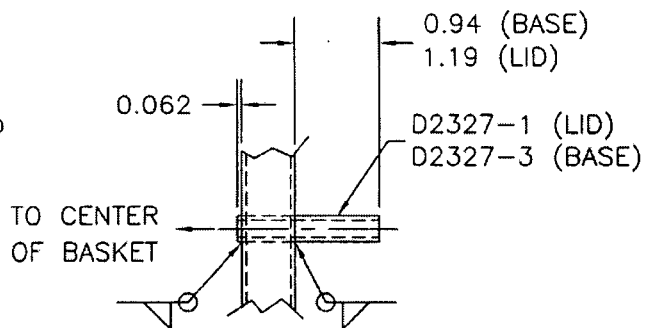
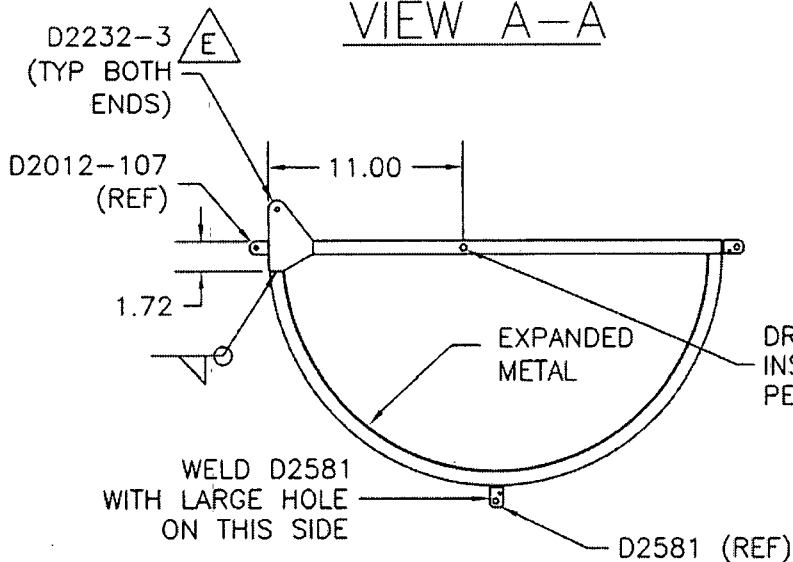
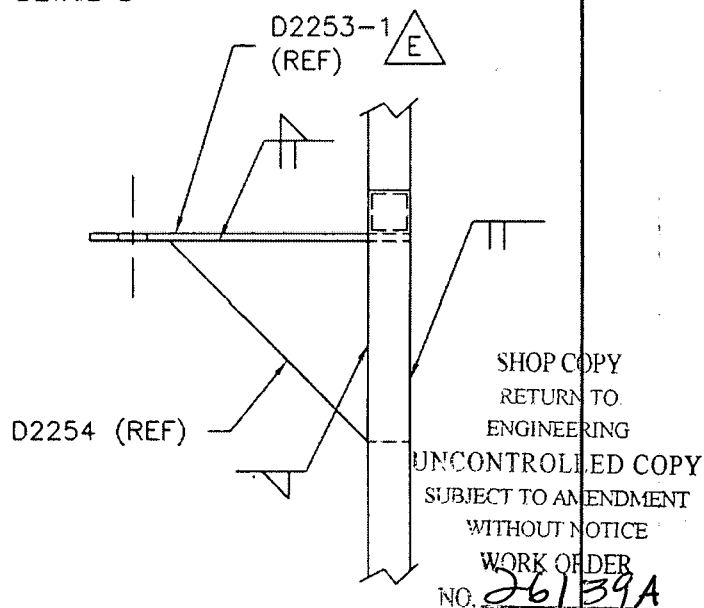
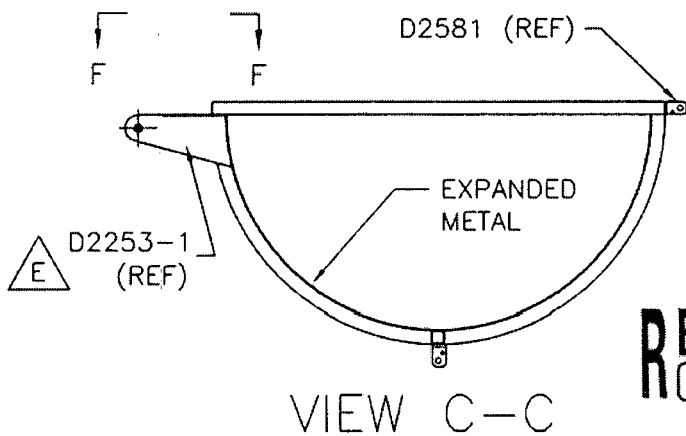
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<i>[Signature]</i>	<i>[Signature]</i>	D2330	SHEET 5 OF 5
DATE	TITLE		SCALE
05.11.10	BASKET ASSEMBLY (206B)		NTS

VIEW A-ADETAIL DVIEW B-BVIEW F-FVIEW C-C**RELEASED**
05.11.26 *[Signature]*

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Date: Wednesday, 3/8/2006 10:43:00 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206B BASKET BASE
Job Number : 26139B	
Estimate Number : 11276	
P.O. Number : N/A	Part Number : D2330041
This Issue : 3/8/2006 S.O. No. : N/A	Drawing Number : UNDER REVIEW D2330
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : E
Previous Run : 22087B	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 4/15/2006 Qty: 1 Um: Each
Checked & Approved By : <u>06.03.08</u>	
Comment : Est Rev:H 06.04 M304EX0.75-16F was M750-16FXS-S/S K	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D31661	Basket Hoop
-----	--------	-------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
4	D3166-1	Hoop	A 25844

06/03/22 ①

2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 25.3019 f(s)/Unit Total : 25.3019 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: M100282

06/03/22 ①

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Cut 4 D2235-1 From D3166-1

2- Cut D2330-1-3-5-7-9 as per Dwg D2330

3-Drill hole in D2330-3 as per Dwg D2330

4-Deburr

06/03/22 ①

4.0	D22531	Lug
-----	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2253-1	Gusset	A 12413

06/03/22 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:43:00 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE

Job Number: 26139B

Part Number: D2330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2012-107 Clevis B25483

AA 06/03/22 ①

6.0

D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-3 Bushing B24874

AA 06/03/22 ①

7.0

D2581

Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2581 Mounting Channel B25834

AA 06/03/22 ①

8.0

D2254

Gusset for D206bskt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2254 Lug B23421

AA 06/03/22 ①

9.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2232-3 HINGE B25239

AA 06/03/22 ①

10.0

D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2012-107 CLEVIS

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:43:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE

Job Number: 26139B

Part Number: D2330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 31.5000 sf(s)/Unit Total : 31.5000 sf(s)

Pick:

Qty Part Number Description Batch

30 sf M304EX0.75-16F Expanded Metal M100230

①
AA 06/03/27

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner JigDeburr as required

A/R SS ROD Batch: M19555

①
AA 06/03/27

13.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

①
PD 06-03-28

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

①
a.m 06-03-29

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

①
M 06 03 30

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



①
u 06-04-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS
C	96.05.23	ADDED LATCH AND LABEL PLATE	
D	99.09.14	MODIFIED LATCH, REDREW	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2330-11	

E {

E {

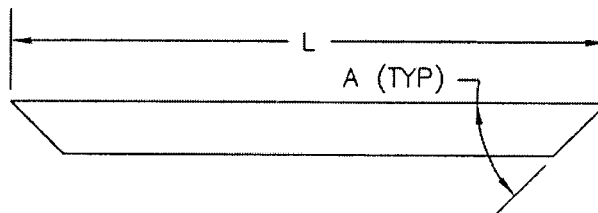
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Qty -041	Qty -043	Part Number	Description	L	A
X		D2330-041	BASKET ASSEMBLY		
	X	D2330-043	LID ASSEMBLY		
1		D2012-107	CLEVIS		
4		D2235-1	RIB		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
2		D2330-1	FRAME	84.00	45
2	2	D2330-3	FRAME	25.50	45
1		D2330-5	FRAME	32.75	90
1		D2330-7	FRAME	24.25	90
1	2	D2330-9	FRAME	24.00	90
	2	D2330-11	FRAME	83.27	45
	2	D2330-13	FRAME	23.63	90
	1	D2330-15	FRAME	33.00	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE
(REF. DART SPEC. M304TS0.075W.0.60)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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CUT SIZE DETAIL

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05-11-26

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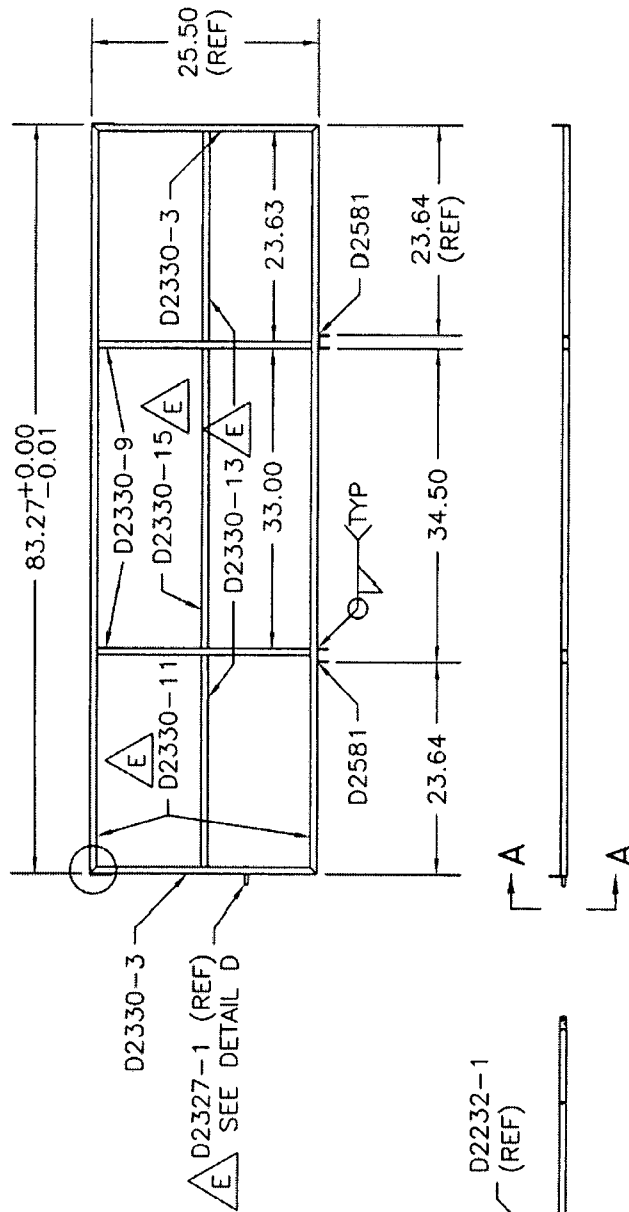
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206B)		SCALE NTS

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AS SHOWN



D2330-043 LID FRAME

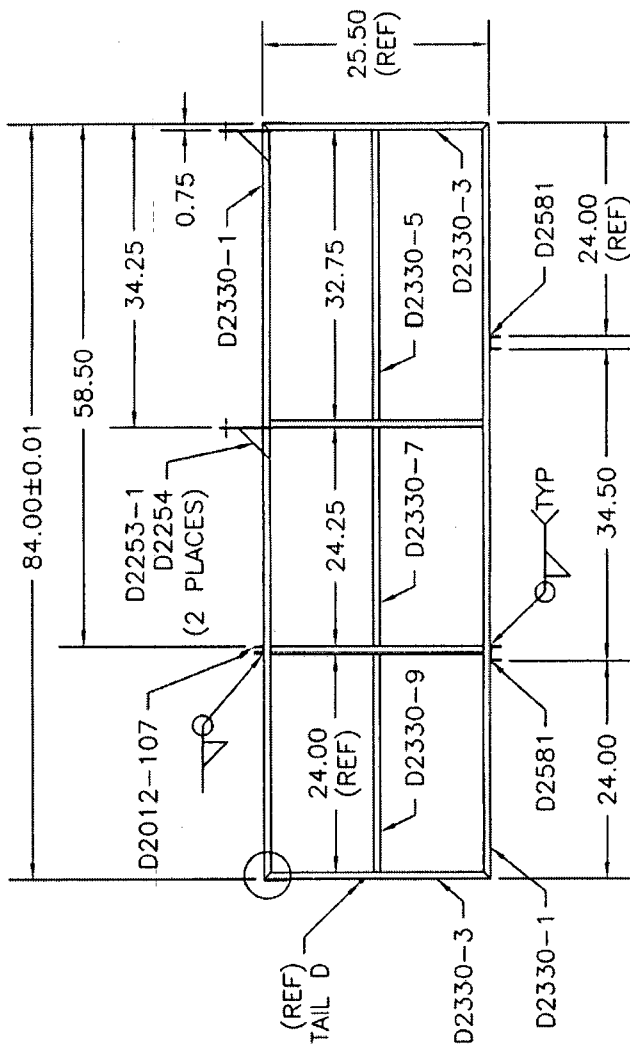
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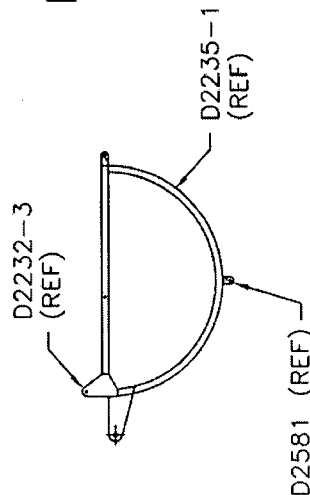
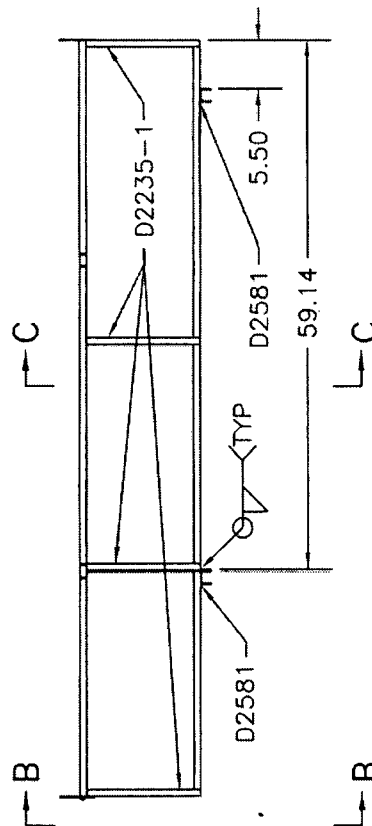


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D2327-3 (REF)
SEE DETAIL D

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

D2330-041 BASKET FRAME

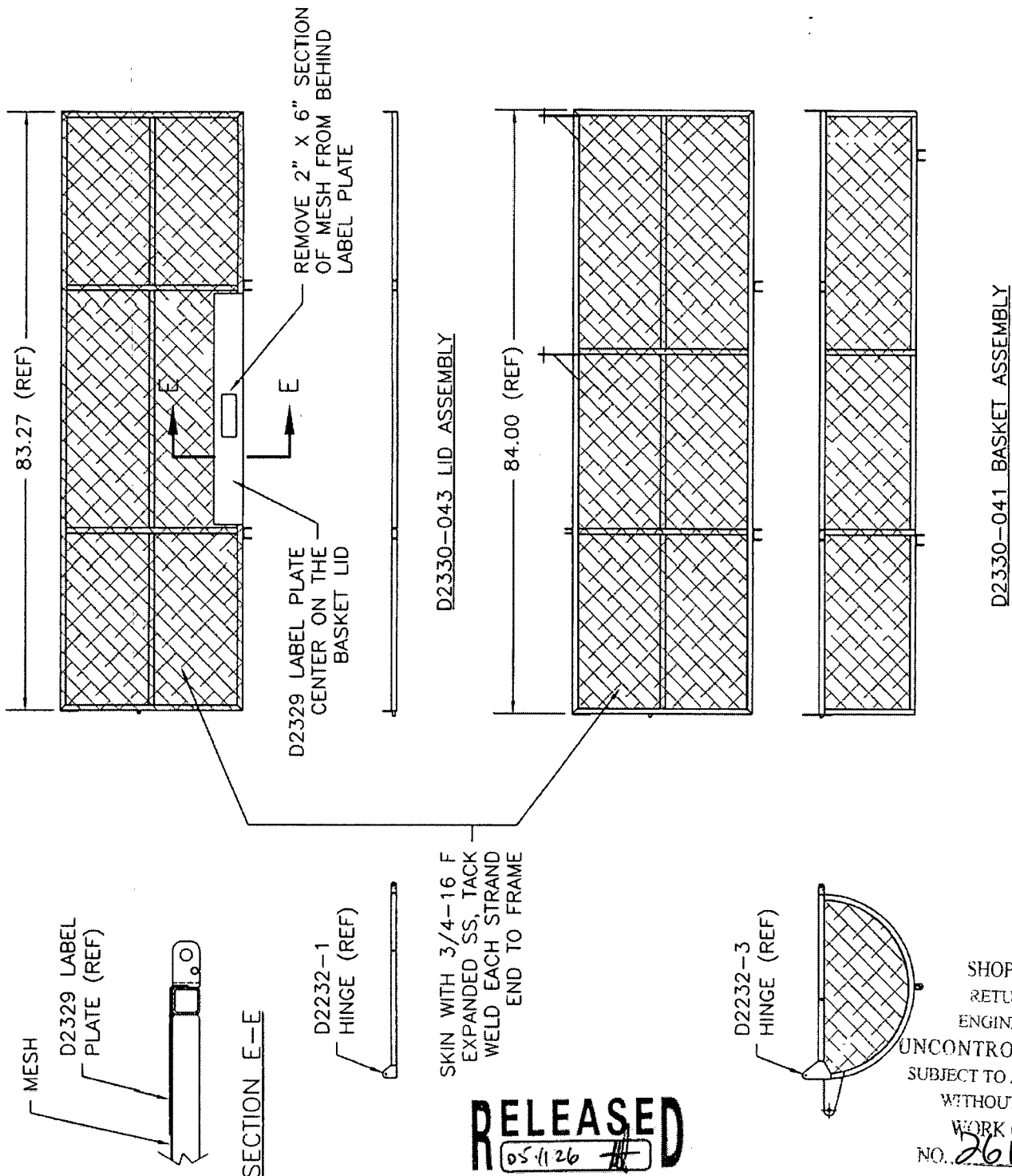
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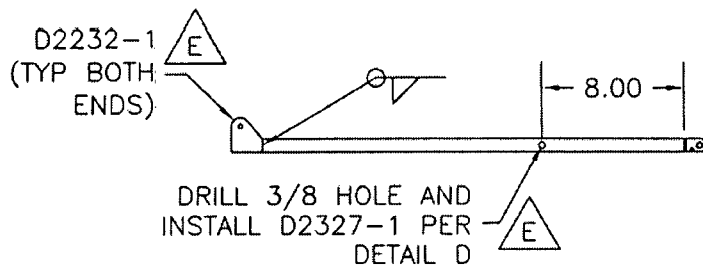
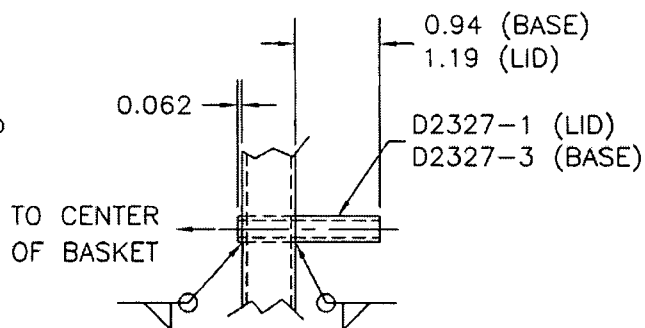
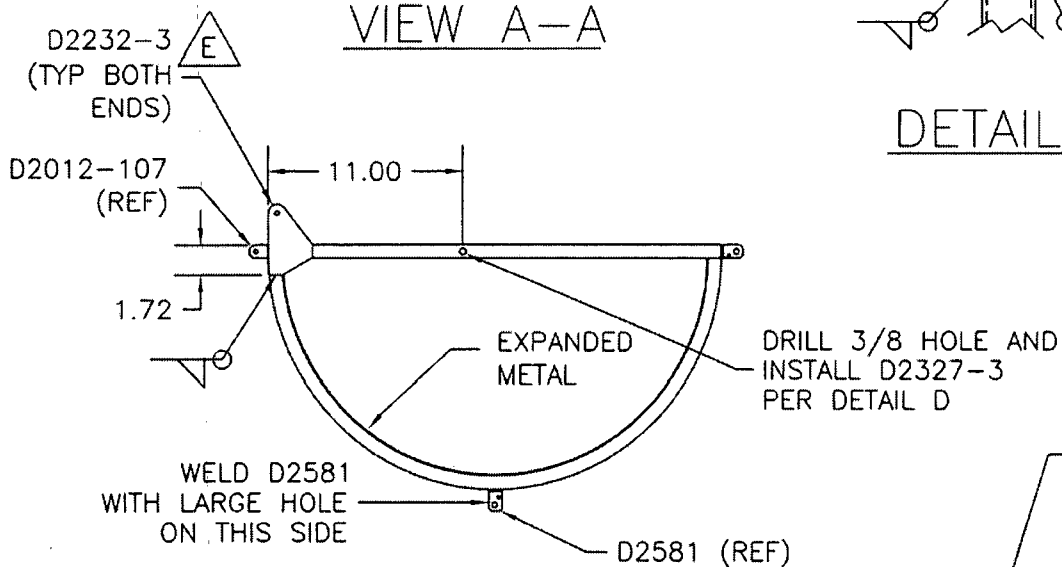
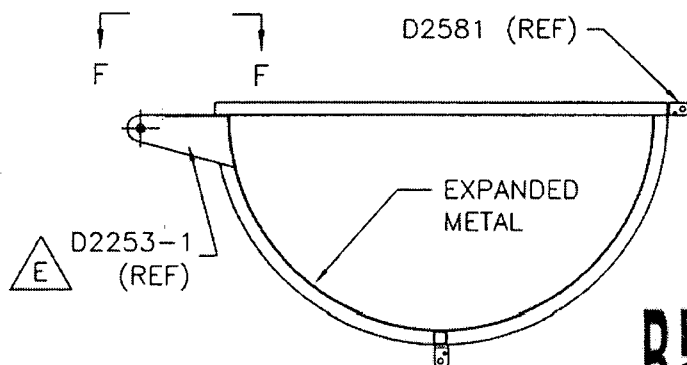
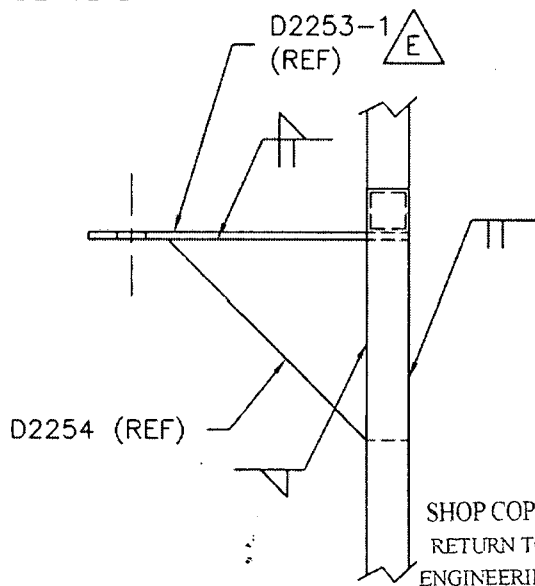
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